



Dart Aerospace Ltd.
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D4016-1

Job Sheet 199766



f198621

Part No: D4016-1

Job Qty: 20 pcs

(40)

Part Name: Hinge Half, Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/27/19

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg
REVA DD 10.02.22 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	9/27/19	9/27/19	0.00	1.30	Bandsaw - 1		<i>19-09-12</i>
110	HAAS 4 Axis - B4B	20 pcs	9/27/19	9/27/19	0.03	8.58	HAAS - 1 - B4B		<i>19-09-12</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs	9/27/19	9/27/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		<i>19-09-12</i>
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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Container No: S213354



Part: D4016-1

Job No: 199766

Serial No/Batch: S213354

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/12/18

Plex 8/30/19 8:08 AM Dart.lajeunesse.marie

160 Packaging 3-1 - Stock - B4B 20 pcs

9/27/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

WAD04-5

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

170 QC 21 - SA

40 20 pcs ✓

9/27/19

0.00 0.00

QC 21 - SA - 21 ✓

WAD04-5

QC 21 - SA - 70

SEP 16 2019

QC 21 - SA - 53

70

9-89

Part Op 100 - CUT BLANK 1.00" LONG

Descriptions: 110 - (HAAS CNC Vertical Machine), MACHINE AS PER FOLIO FA869 AND DWG

130 - (QC8- Inspect parts - second check

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B1.000X1.000	304 Bar 1.00 X 1.00	1.6000 ft (.08 ea)	100-Bandsaw - 1	S190197

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304B1.000X1.000	2	31	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Base	0.875Inches ± 0.010	0.885 0.865		
2	Hinge Half, Base	0.250Inches ± 0.030	0.280 0.220		
3	Hinge Half, Base	0.380Inches $+ 0.030$ $- 0.000$	0.410 0.380		
4	Hinge Half, Base	0.030Inches ± 0.030	0.060 0.000	Radius	
5	Hinge Half, Base	0.130Inches ± 0.030	0.160 0.100		
6	Hinge Half, Base	0.880Inches ± 0.030	0.910 0.850		
7	Hinge Half, Base	0.257Inches $+ 0.006$ $- 0.001$	0.263 0.256	Diameter	
8	Hinge Half, Base	0.380Inches ± 0.030	0.410 0.350	Radius	
9	Hinge Half, Base	0.500Inches ± 0.030	0.530 0.470		
10	Hinge Half, Base	0.750Inches ± 0.030	0.780 0.720		

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		QTY Affected :		Disposition		MRB (QS1042)					
Date : _____		Sequence # : _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality			
Description Work Order Deviation				Completed By								QC / QA Coordinator			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY											
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: _____				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function				Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			